

Work Order ID 161000

Friday, May 05, 2017 3:36:12 PM

161000

SCRAP

Page 1

Item ID: D4726-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle

Start Date: 5/12/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/29/2017 Req'd Qty: 8.00

8

Customer:

Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: PA ^{DAS} 21

Date: 2017/05/10

Tooling:

Date:

Run Start *NR1*

QC: 9-89

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4726

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.20

Jeaspa Bandsaw

CUT BLANK AT 2.00"

8 10 MK / 9ml
17/05/14

110

1.46

110

HAAS 1

Memo

2.11

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB132

FOLIO REV: A

DWG REV: A

8 17-05-14

DEBURR

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Page 2

Item ID: D4726-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Handle
Start Date: 5/12/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 5/29/2017 Req'd Qty: 8.00 *8* Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				8			17-05-014
120									
QC	Memo	0.08							
Quality Control									
130	QC8- Inspect parts - second check	0.00				8	0		DAS 44 9-09 17-05-15
130									
QC	Memo	0.16							
Quality Control									
132	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
132									
Outsource4	Memo	1,440.00							
Outsource process - Anodize									

- MPP-172 Section 2.1
- HARD ANODIZE 1AW Mil-A-8625 Type3 Class2
- color BLACK

DAS
03
8-08
17-5-24

part no good. right
8 not made to the REV.
DAS
13
MAY 9 5 2017
MAY 9 2017

PTO
→

DQA:

Date: 2017-07-10



QA Closed:

Date: JUL 03 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>161000</u> Part No. <u>D4726-1</u> NCR No. <u>17-6486</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐						
Date: <u>17-06-16</u>		Step #: <u>8 132</u>		QTY Effective: <u>3</u>			MRB (QSI042) Approval DAS 9 9-89 <u>17-06-16</u>			
Description Work Order Deviation				Disposition				Completed By DAS 10 9-89 JUN 16 2017		
Parts were brought back to from ATG because of a design change.				Scrap destroy as per ECN 17-571				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>17-06-16</u>		
								QC / QA Coordinator Approval DAS 9 9-89 <u>17-06-16</u>		
Root Cause Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ ☒ Drawing Finish ☐ Misread ☐ Turning Sequence ☐
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Page 3



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OTHER : _____																									

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04

JUN 16 2017

M606/T6B.750X2.060

M136463 → 1.44

an/ 17/05/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

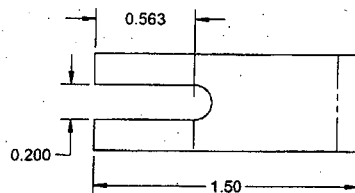


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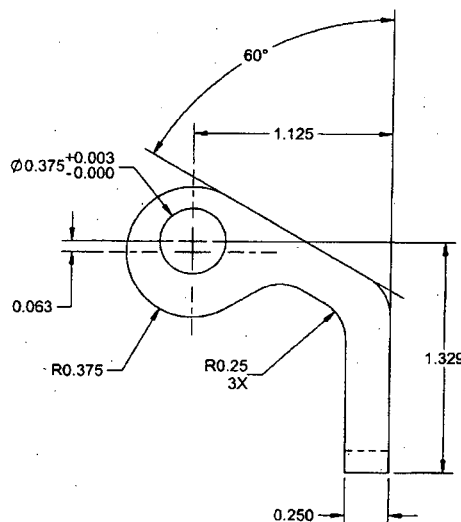
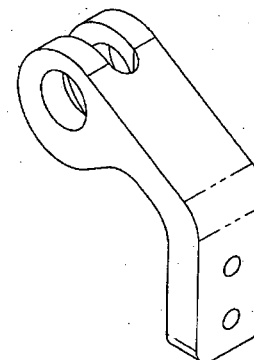
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

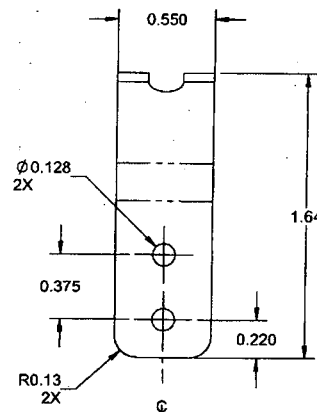
Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161000 MJS
120510



↑
GRAIN
DIRECTION



D4726-1 HANDLE

NOTES:

- 1) MATERIAL: ALUMINUM, 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4726-1" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.04 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DWG FILE "D4726-1-REVA.STP"

A		NEW ISSUE		RP	12.09.19
REV.	DESCRIPTION			BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA			
DRAWN	RP				
CHECKED	AP	DRAWING NO.	REV. A		
MFG. APPR.		D4726	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR.		HANDLE	NTS		
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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